

Work Order ID 54712-2

December 16, 2009 3:28:43 PM

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 16/12/2009 Start Qty: 6.00

Required Date: 21/12/2009 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100



Waterjet

FLOW CNC Waterjet

6001 - C80

FLOW WATER JET

0.00

Memo

1-Cut as per Dwg D2492
Deburr if necessary

Dwg Rev:

F

Prog Rev:

F

2-

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

77 8060107

(10)

IB 10-1-6

IB 10-1-6

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Work Order ID 54712

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Page 2

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Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form using Jig DT2492B

0.00

0.00

SAP
10-01-19

(2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ S1010120

(12) ✓

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

⇒ M 10/01/20

(12) ✓

Work Order ID 54712

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Page 3

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 16/12/2009 Start Qty: 6.00

Required Date: 21/12/2009 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10-01-20

(2) ✓

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME:

8:30am FINISH TIME:

8:00am

OVEN TEMPERATURE:

320°F

0.00

7 M 10-01-20

(x2) ✓

180



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10-01-20

(2) ✓

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QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop



Cust Item ID:

Customer:



Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: G-A

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

ES 10/01/20 (2)

10/01/20 J

MF
10-1-20

Picklist Print

December 16, 2009 3:28:47 PM

Work Order ID: 54712

Parent Item: D2492

Parent Item Name: Patient Stop

Comments:

Start Date: 16/12/2009

Required Date: 21/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	370.3809	11.5131	20,		



6061-T6 .080 Sheet



B 10-1-6

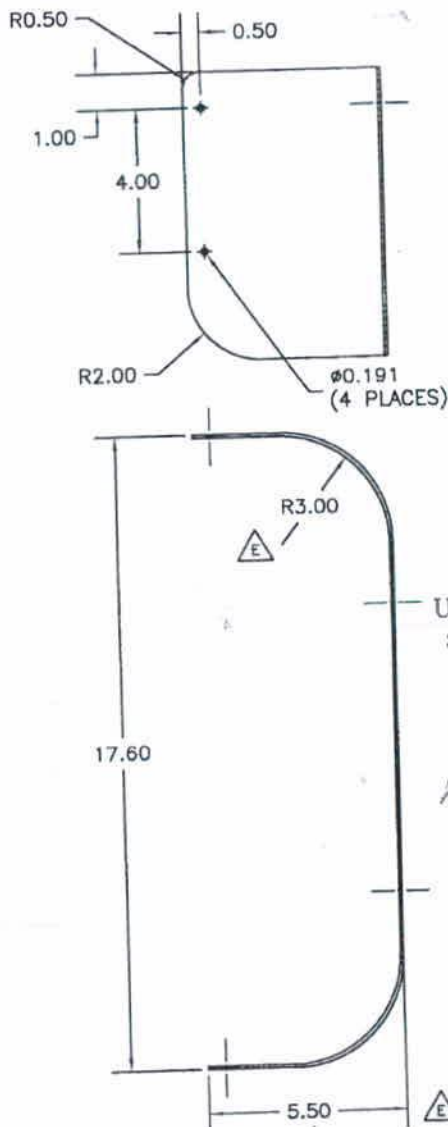
<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	370.38087	
110630	33.5136	
112141	0.86727	
113438	336	

10

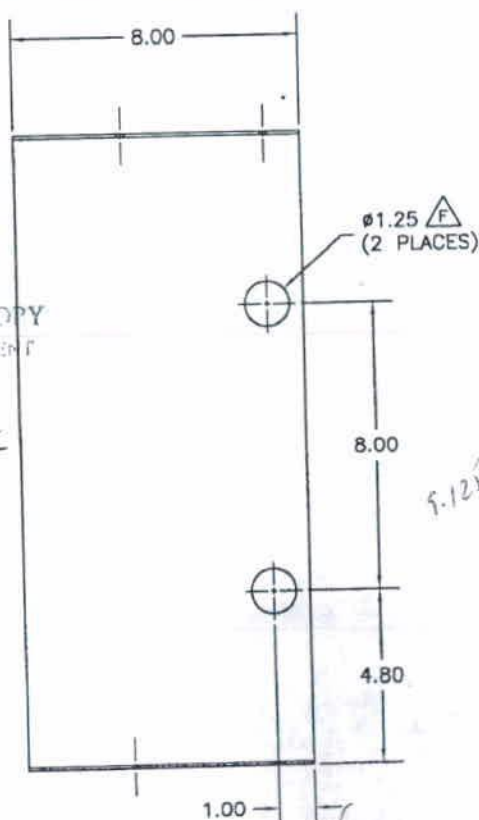
113438

DART

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54712
PH 09-12-16

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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